

Work Order ID 62170

Monday, September 20, 2010 10:16:25 AM

Page 1

Item ID: D3685-041

Accept

Setup Start

Revision ID:

Stop

Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 9/20/2010 Start Qty: 1.00

Required Date: 10/1/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-9-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3685

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3685

SB 10/09/21

10/09/21

SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8.10.12.1

QC

Memo

0.00

Quality Control

(x)

130

Identify as per dwg & Stock Location: B910

0.00

Packaging

Memo

0.00

Packaging

10/9/22 sf

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/09/23

mf

10-9-23

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NOTE: Date & initial all entries

Monday, September 20, 2010 10:16:24 AM

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY





Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	86.0000	4	4		10/09/21	
Bolts													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				86					
				112314				8					
				114761				11					
				115392				47					
				115594				20					
D3684-047 		Manufactured	No			110	Each	0.0000 B62164	1	1		10/09/21	
FWD LEG ASS'Y													
D3684-049 		Manufactured	No			110	Each	0.0000 B62165	1	1		10/09/21	
AFT LEG ASS'Y													
D3687-3 		Manufactured	No			110	Each	5.0000	1	1		10/09/21	
MOUNT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST075				5					
				61964				5					

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 62170



Parent Item: D3685-041



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 9/20/2010

Required Date: 10/1/2010

Start Qty: 1.00

Required Qty: 1.00

D3692-1 Manufactured No

110

Each

349.0000

8

8



SPACER



SB 10/02/21

Location

Loc Qty

Loc Code

ST082

349

51467

349

8

MS21043-3

Purchased

No

110

Each

2,643.000

4

4



SB 10/09/21

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2567

109147

4

111383

46

112314

2517

4

W/O:		WORK ORDER CHANGES					
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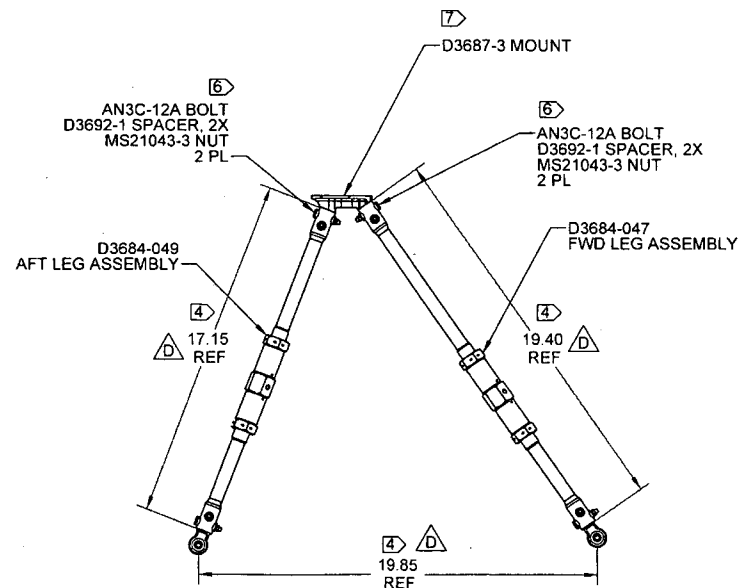
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in.-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
2010-03-15
MP

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3685	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BIPOD MOUNT ASSEMBLY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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